

**Work Order ID 104999****\*104999\***

Page 1

July-23-13 12:58:37 PM

Item ID: D4020-7

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Mesh (350 Basket Short, Lid)

Stop

**\*NS2\***

Start Date: 7/23/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: ML5Date: 13-07-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4020	A								
100		0.00							
<b>*100*</b>	FLOW WATER JET								
Shear	Memo	0.00							
Shear	1-Cut as per Dwg D4020								

110	QC6- Inspect dimensions to drawing	0.00	<u>DAS</u> <u>24</u> <u>8-89</u>	<u>13.8.20</u>	<u>D</u> <u>f</u>
<b>*110*</b>	Memo	0.00			
QC					
Quality Control					

120	Identify as per dwg & Stock Location: <u>W1004</u>	0.00			
<b>*120*</b>	Memo	0.00			
Packaging					
Packaging					

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

Landing Gear		General									
Bending		Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
Centre Not Concentric to O/S		BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
Cracks		Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>						
Crushed/Crimped		Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
Cuffs		Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>							
Heat Treat		Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
Inspection Strip in Tube		Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>						
Ripples in Bend		Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>								
Torque Waves in Extrusion		Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
Turning Sequence		Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
Wave/Twist in Tube		Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

Work Order ID 104999

\*104999\*

Page 2

July-23-13 12:58:37 PM

Item ID: D4020-7

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Mesh (350 Basket Short, Lid)

Stop

\*NS2\*

Start Date: 7/23/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

\*130\*

QC

Quality Control

Memo

0.00

MJ 13-08-21

MJ 13-08-21

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>					
	Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>						
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>		Other <input type="checkbox"/>					
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

# Picklist Print

July-23-13 12:58:36 PM

Page 1

Work Order ID: 104999

Parent Item: D4020-7

Parent Item Name: Mesh (350 Basket Short, Lid)

Start Date: 7/23/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC  
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	1,530.9667	8.4578	8.9029474		13-08-2013	PD

Location	Loc Qty	Loc Code
MAT	176.2791180	
125113	176.279118	
WA	209	
125457	209	
WA007	1145.687606	
123448	15.96	
125457	4.691526	
125605	480	
M126052	90.02608	
M126134	555.01	8.90

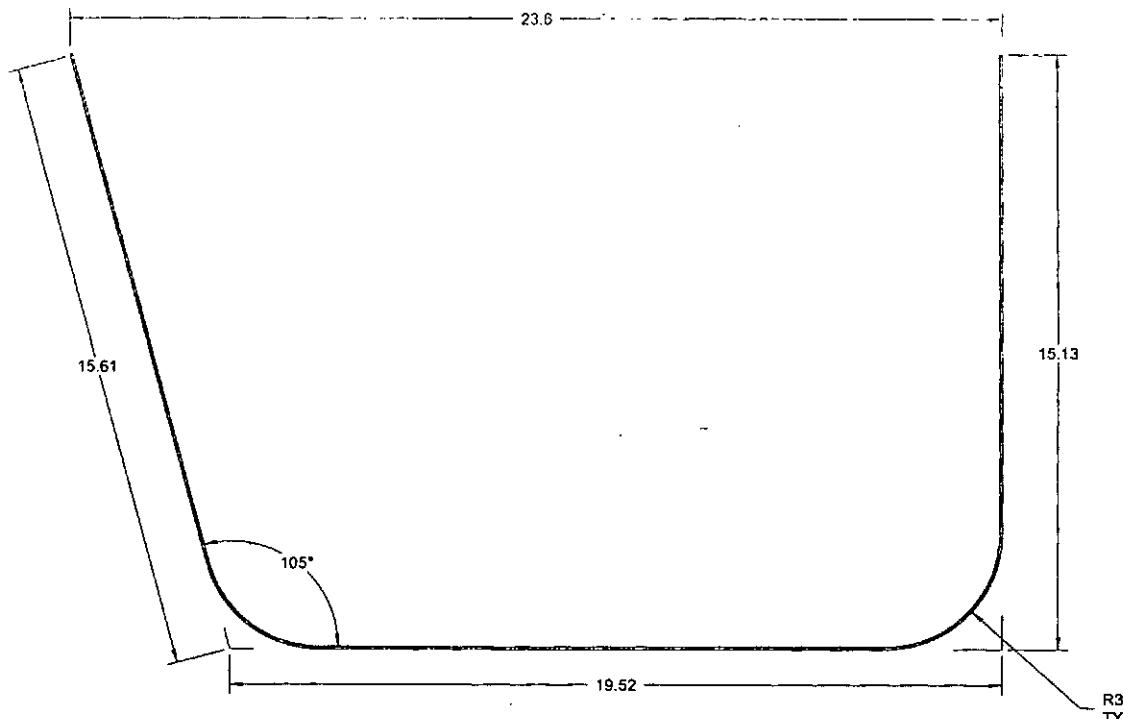
NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	<input type="checkbox"/> Bend			Grain	<input type="checkbox"/> Ovalized			<input type="checkbox"/> Pressure/Forced			
Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route			Hardware	<input type="checkbox"/> Over/Under tolerance			<input type="checkbox"/> Temperature/Cure			
Cracks	<input type="checkbox"/> Broken/Damaged			Inspection Incomplete	<input type="checkbox"/> Part Incorrect			<input type="checkbox"/> Weld			
Crushed/Crimped	<input type="checkbox"/> Burrs			Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing			<input type="checkbox"/> Wrong Stock Pulled			
Cuffs	<input type="checkbox"/> Contamination			Maintenance	<input type="checkbox"/> Part Moved						
Heat Treat	<input type="checkbox"/> Countersink			Mislabeled	<input type="checkbox"/> Positioned Wrong						
Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short			Misread	<input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Other			
Ripples in Bend	<input type="checkbox"/> Drill Holes			Offset							
Torque Waves in Extrusion	<input type="checkbox"/> Drawing			Out of Calibration							
Turning Sequence	<input type="checkbox"/> Finish			Out of Sequence							
Wave/Twist in Tube	<input type="checkbox"/> Folio			Outside Dimensions							



104999 MCL  
13-07-21

⑨ D4020-1 MESH (350 BASKET LONG, BASE)  
(SEE D4020-1F FOR LENGTH)

⑨ D4020-3 (350 BASKET SHORT, BASE)  
(SEE D4020-3F FOR LENGTH)

RELEASED  
2010-03-12  
AP

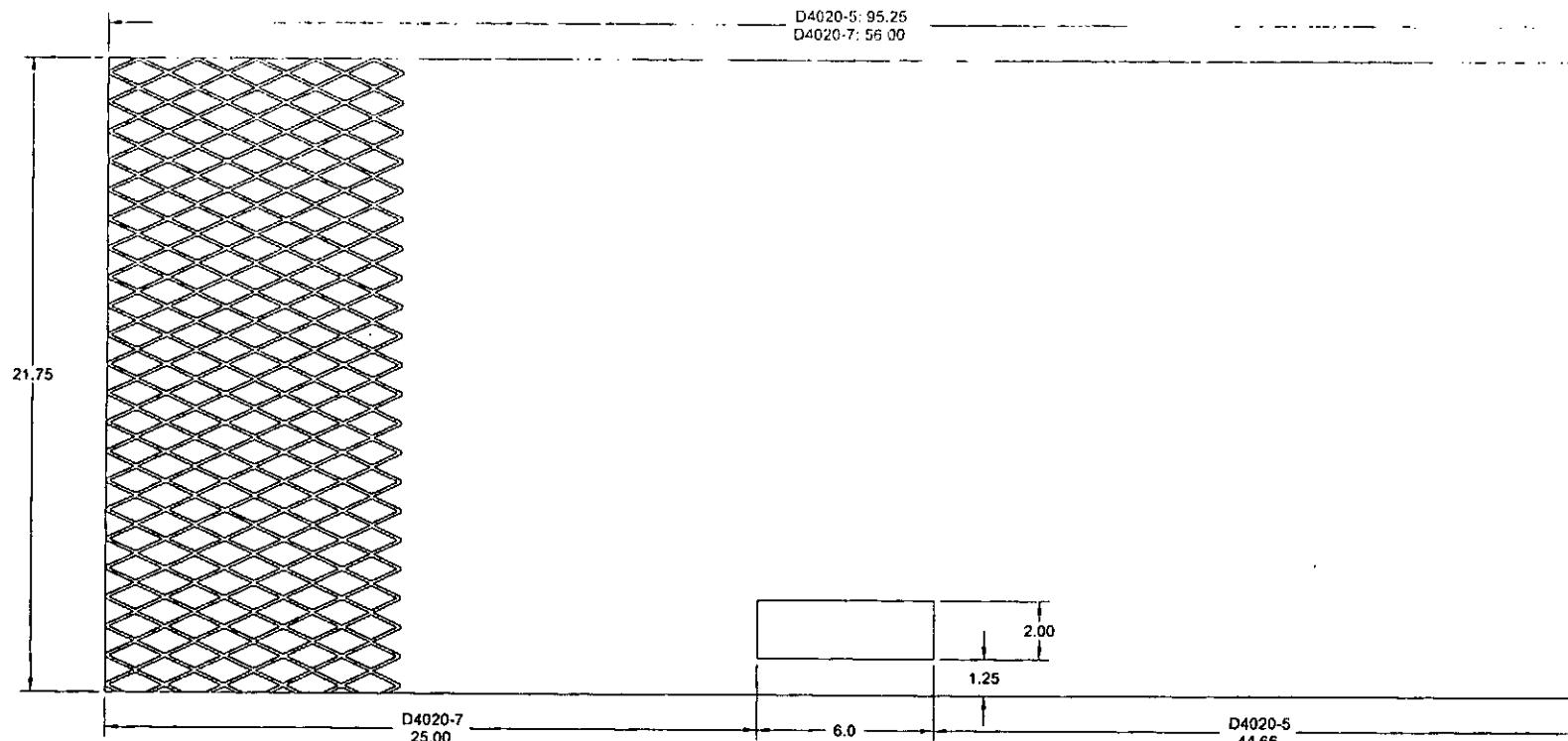
NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F  
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

8 7 6 5 4 3 2 1

A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	GD	DRAWING NO.	REV. A		
MFG. APPR.	EZ	D4020	SHEET 1 OF 4		
APPROVED	SM	TITLE	SCALE		
DE APPR.	SM	350 BASKET MESH (BASE)	NTS		
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED UNDER CONTRACT. IT IS A MATERIALS SPECIFICATION AND IS NOT TO BE COPIED OR DISCLOSED WITHOUT PERMISSION FROM DART AEROSPACE LTD.			

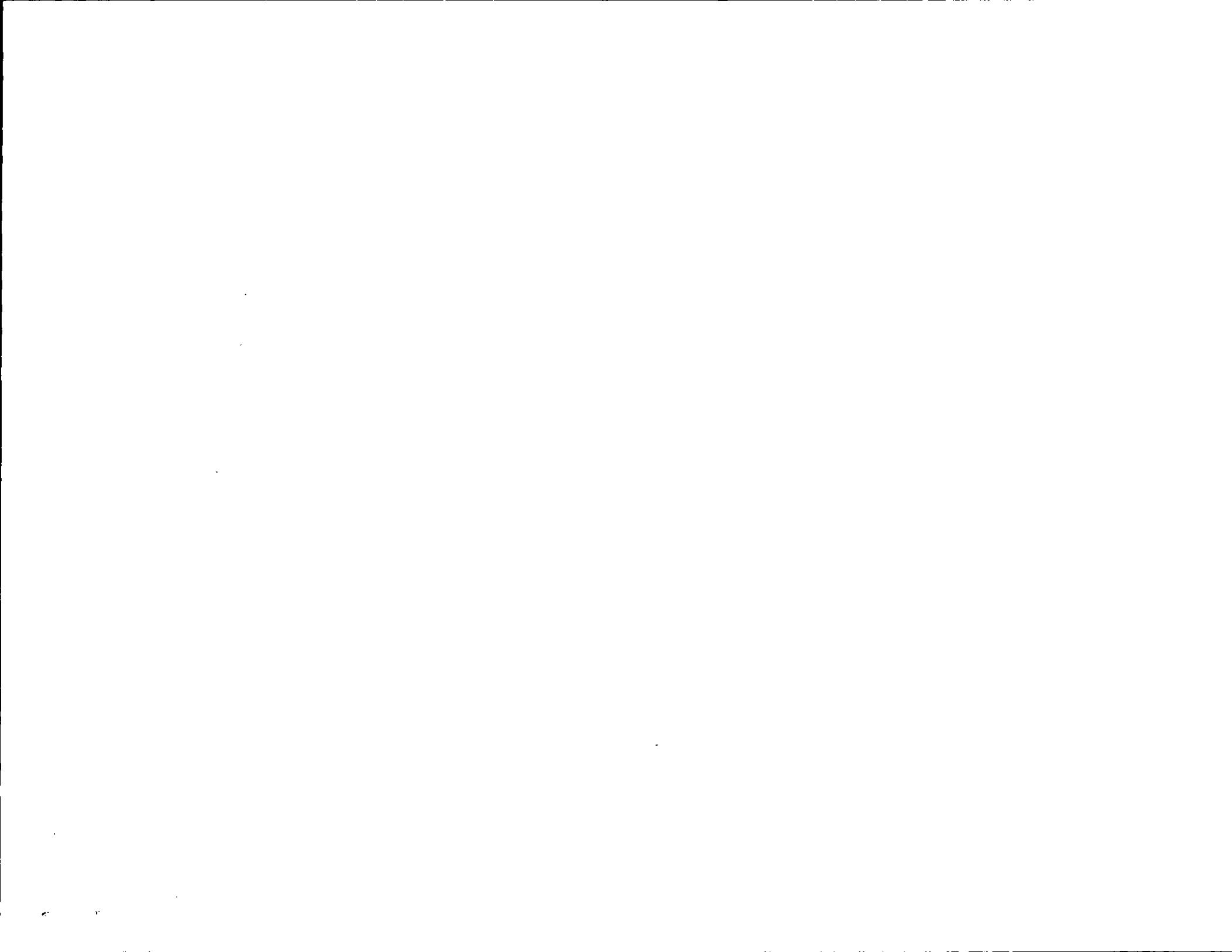


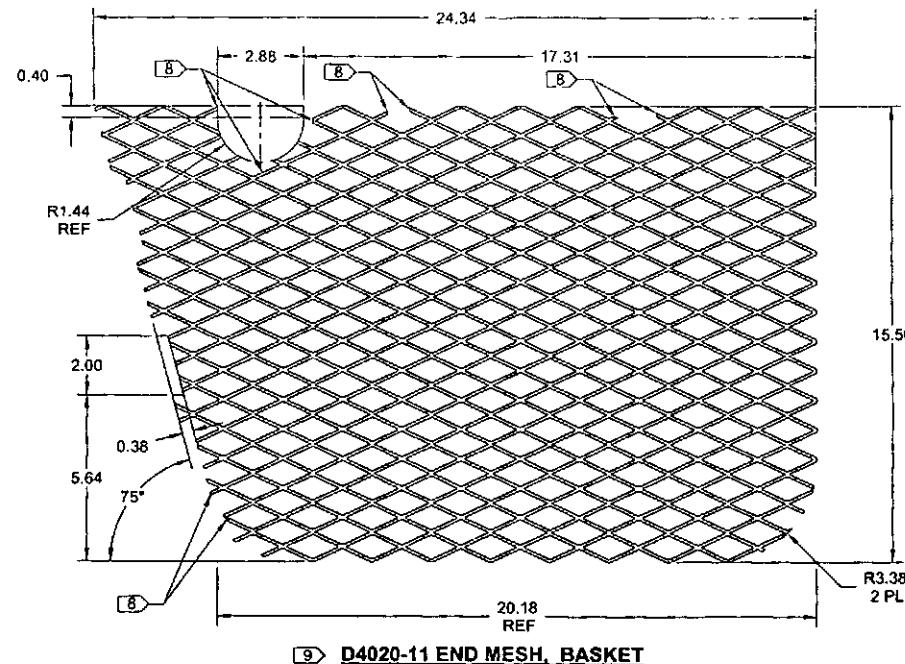
D4020-5: 95.25  
D4020-7: 56.00⑨ D4020-5 MESH (350 BASKET LONG, LID)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)⑨ D4020-7 MESH (350 BASKET SHORT, LID)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)RELEASED  
2010-03-12  
JW

## NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX  
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKSBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. A
MFG. APPR.	✓	D4020	SHEET 2 OF 4
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED WITHOUT PRIOR WRITTEN APPROVAL FROM DART AEROSPACE LTD	





RELEASED  
2010-03-12  
JMP

## NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

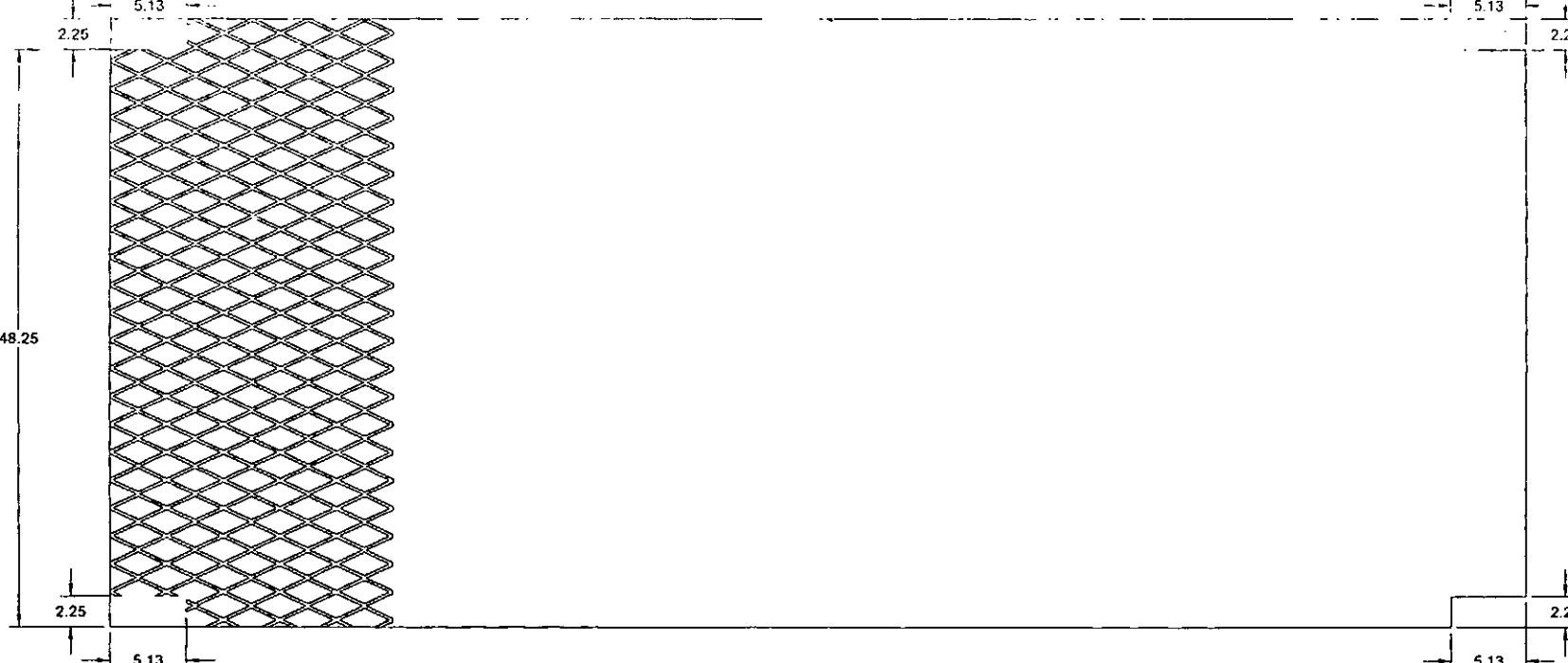
8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	
MFG. APPR.	<i>g</i>	REV. A	
APPROVED	<i>g</i>	D4020	
DE APPR.	<i>g</i>	SHEET 3 OF 4	
DATE	10.03.04	TITLE	SCALE
		350 BASKET MESH (BASE)	NTS

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BY DART AEROSPACE LTD



104999

D4020-1F 95.25  
D4020-3F 56.00

⑧ D4020-1F MESH (350 BASKET LONG BASE)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

⑧ D4020-3F MESH (350 BASKET SHORT, BASE)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED  
2010-03-13  
MM

## NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 17.33 lbs APPROX  
-3F: 10.16 lbs APPROX
- 8) TOLERANCE ON XX.XX DIMENSIONS  $\pm$  0.06.

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	PP	DRAWING NO. REV. A
MFG. APPR.	PP	D4020 SHEET 4 OF 4
APPROVED	PP	TITLE
DE APPR.	PP	SCALE
DATE	10.03.04	NTS

350 BASKET MESH (BASE)

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